

Date: Monday, 4/24/2006 10:25:40 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: TUBE ASSEMBLY		
Job Number	: 26763		Part Number	: D3304041		
Estimate Number	: 11198		Drawing Number	: D3304 REV. B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 4/24/2006		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 5/16/2006		
Previous Run	: "		Qty:	4		
Written By	: <i>[Signature]</i>		Um:	Each		
Checked & Approved By	: <i>[Signature]</i> 06.04.24					
Comment	: Est: C04.11.17 Step 13 revised KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304/TR0875W065	SS TUBING	
		Comment: Qty.: 1.4109 f(s)/Unit Total : 5.6435 f(s) Material: AISI 304/316 SS tubing 0.875" x 0.065" wall (M304TR0.875W.065) Identify for D3304-1 Batch: <i>M16258</i>	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL Cut blank: 15.75" as per Dwg D3304 Turn as per Folio FA458 and Dwg D3304 Identify as D3304-1 <i>N/A Machined Manually</i>	<i>06/06/13</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>06/06/13</i>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>06/06/13</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Drill as per Dwg D3304 using drill Jig D3304-T1 Deburr	<i>FF 06-09-25</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/24/2006 10:25:40 AM
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Drawing Name: TUBE ASSEMBLY

Job Number: 26763

Part Number: D3304041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/09/25

(4)

7.0 D33045

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bracket

Pick:

Qty Part Number Description Batch

1 D33045

Bracket B23980

PD

06-10-24

(7)

8.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bracket as per Dwg D3304 and QSI 004

PD

06-10-24

(4)

9.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AA 06/10/25

(4)

10.0 POWDER COATING

POWDER COATING



M19720

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4:3

YL

06/10/26 x 4

4

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FF 06-10-26

12.0 BLBS0016

PIP PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

PIP PIN

Pick:

Qty Part Number Description Batch

1 BLBS-0016 Pip Pin

H100726

FF 06-10-26

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/16/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/24/2006 10:25:40 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 26763

Part Number: D3304041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 CBL460 Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Loop Sleeve

Pick:

Qty	Part Number	Description	Batch
2	CBL-460	Loop Sleeve	17100644

FF 06-10-26 4

14.0 CBL1240 Cable



Comment: Qty.: 1.0417 f(s)/Unit Total : 4.1668 f(s)

Cable

Pick:

Qty	Part Number	Description	Batch
12.5"	CBL-1240	Cable	1716713

FF 06-10-26 4

15.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble lanyard and pip pin as per Dwg D3304

FF 06-10-26 4

16.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 06/10/07 7

17.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: 109/10/27 (4)

18.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/10/07 4

Job Completion



U 06/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26763
Description: Tube Assembly	Part Number:	D3304-1
Inspection Dwg: D3304	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

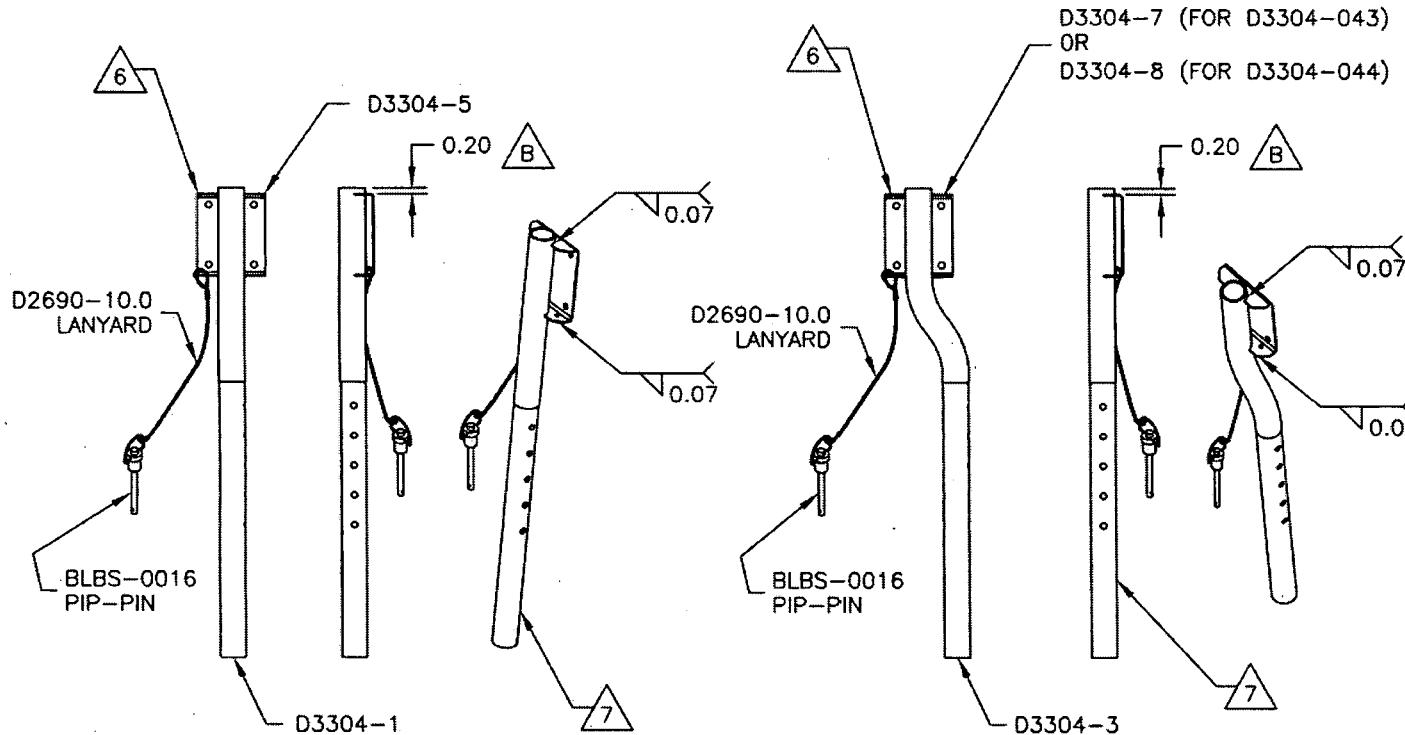
X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	06/06/13	Date:	06.06.13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.08	New Issue P/O D3304-041	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	<i>[Signature]</i>

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD	
CHECKED <i>W</i>	APPROVED <i>W</i>	DRAWING NO. D3304	REV. B
DATE 05.07.15		TITLE TUBE ASSEMBLY	SHEET 1 OF 4
A	04.08.18	NEW ISSUE	SCALE 1:6
B	05.07.15	UPDATE DIMENSIONS; ADD D3304-7/-8	



D3304-041 TUBE ASSEMBLY (SHOWN)
D3304-043 OPPOSITE

RELEASED
25-08-11
W

D3304-041/-043/-044 NOTES:

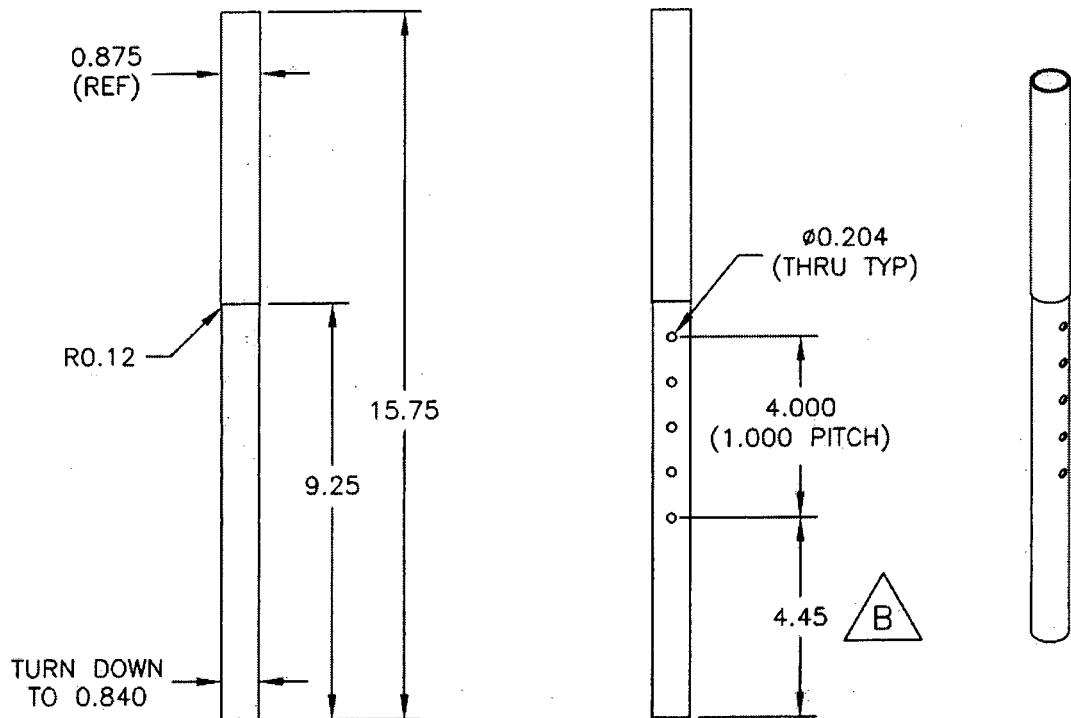
- 1) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO *26163*

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3304	REV. B SHEET 2 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:1

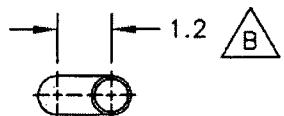
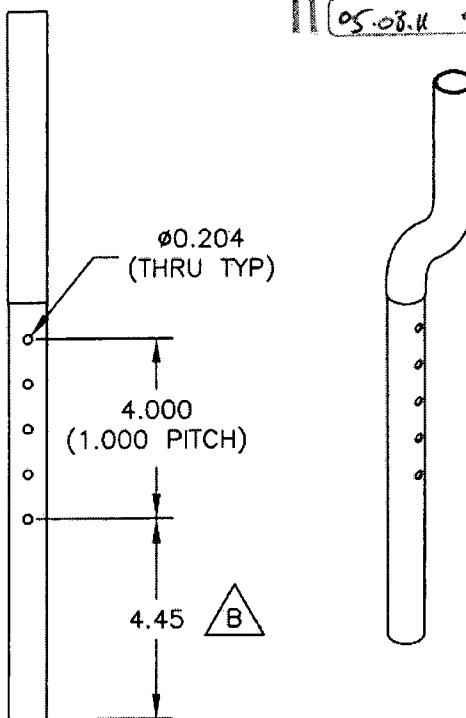
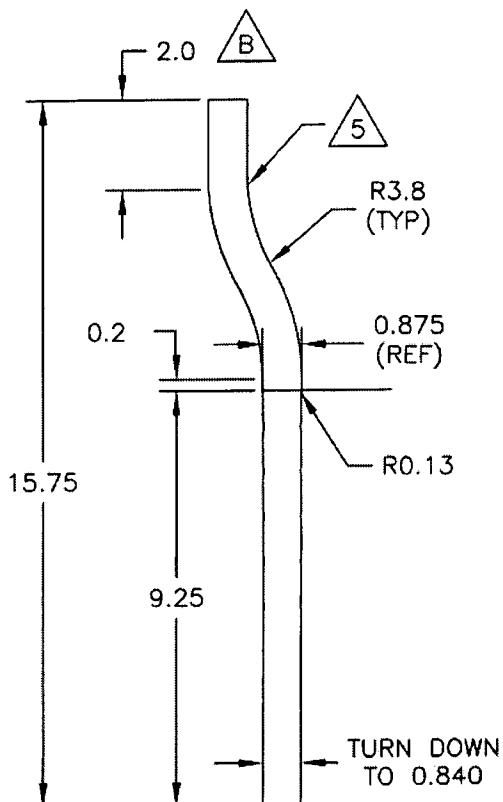
RELEASED
05.08.11 *MM***D3304-1 TUBE****D3304-1 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\varnothing 0.875 \times 0.065$ WALL
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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WORK ORDER
NO. 26163

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3304	REV. B SHEET 3 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4

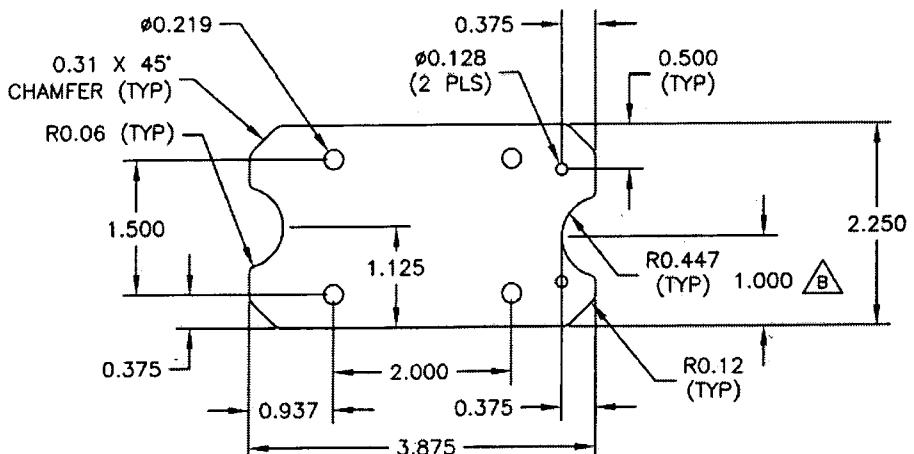
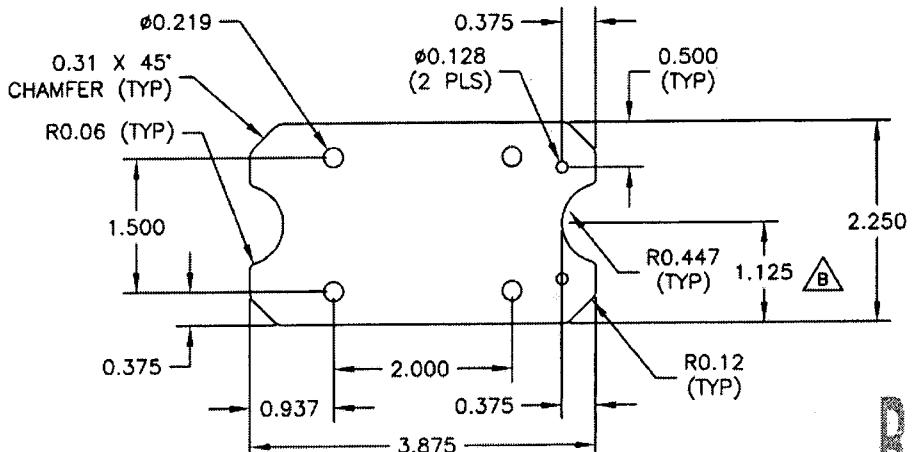
**D3304-3 TUBE****D3304-3 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.875 x 0.065 WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

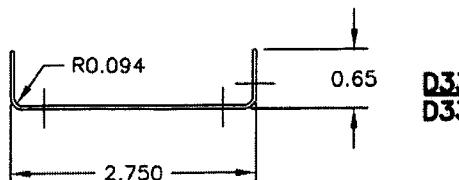
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WORK ORDER
NO. 26763

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 4 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:2



D3304-7/-8 FLAT PATTERN



**D3304-5/-7 BRACKET
D3304-8 OPPOSITE**

B
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WITHOUT NOTICE
WORK ORDER
NO. 26763

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015